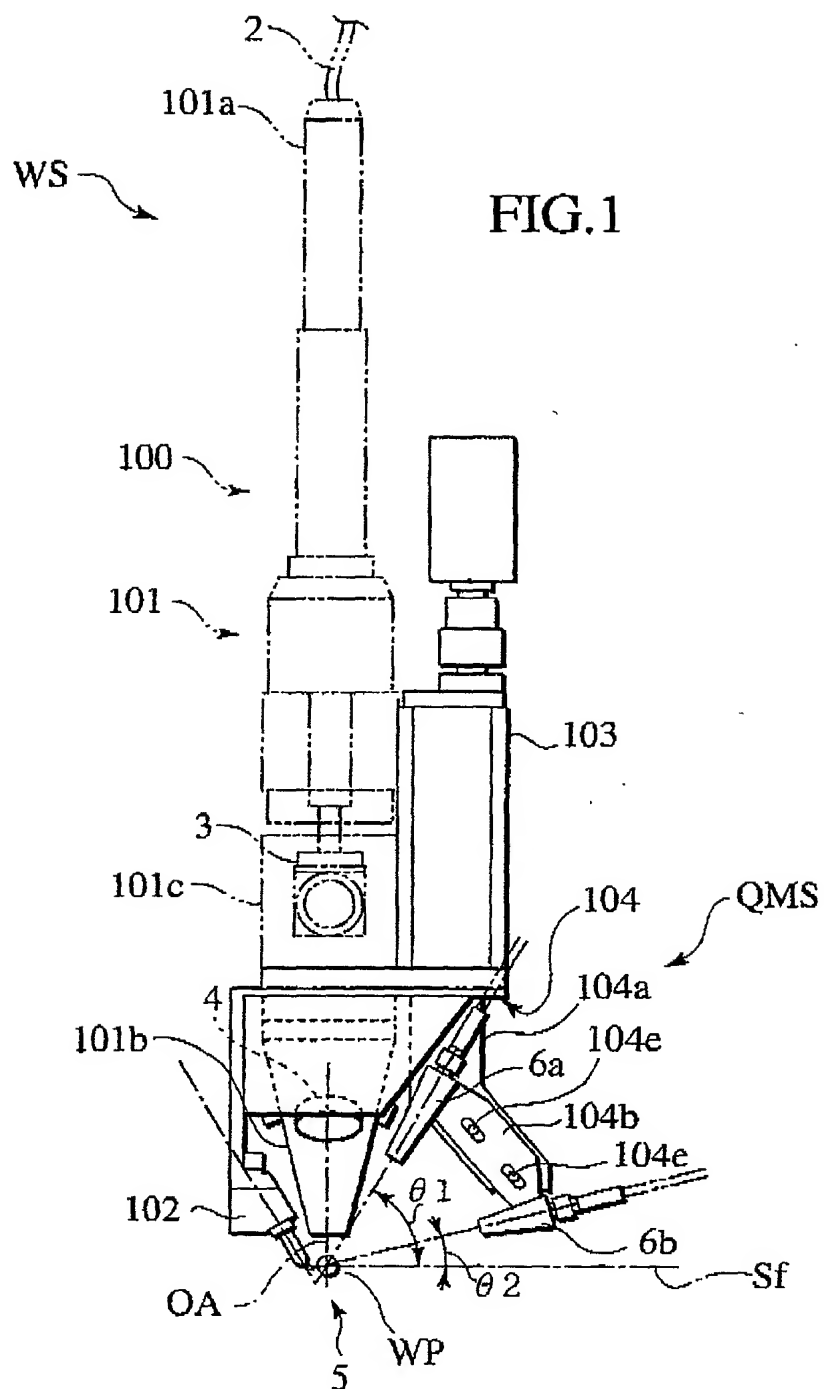


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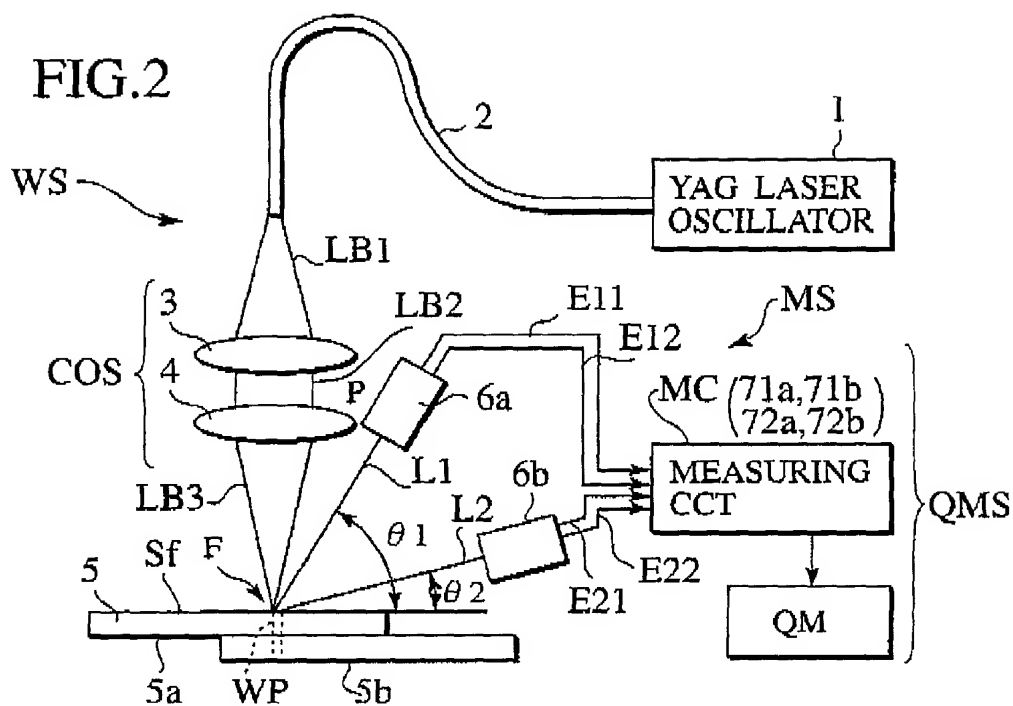
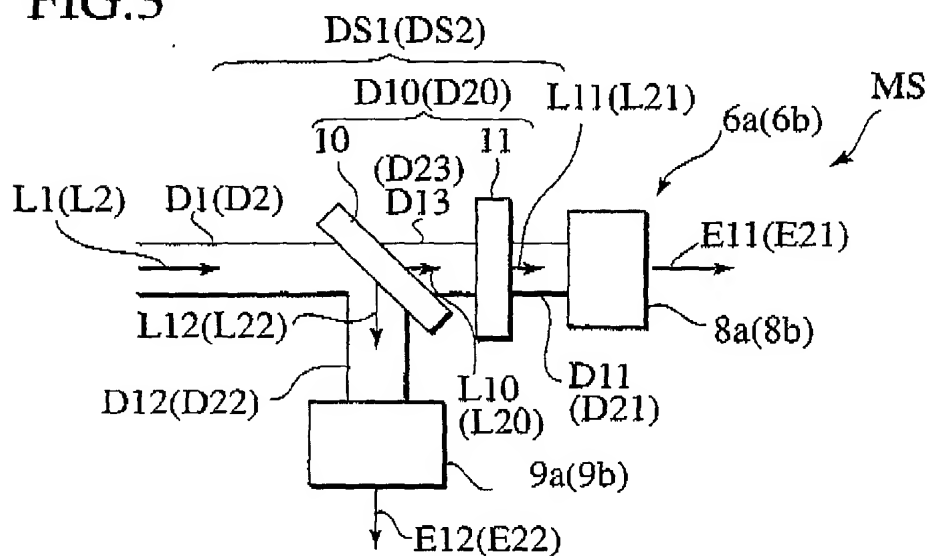
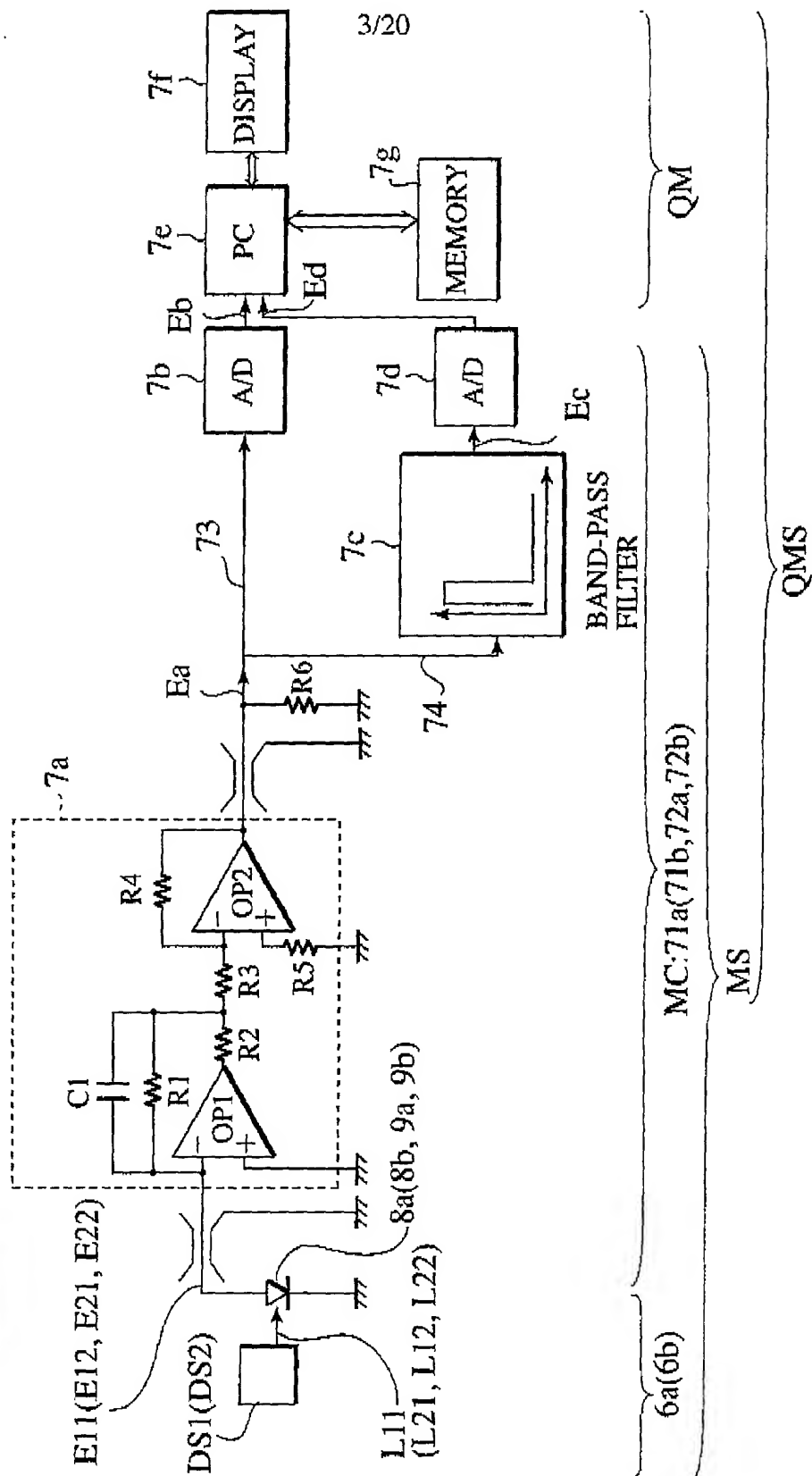
**FIG.3**

FIG.4

PL:PL1a(PL1b,PL2aPL2b)



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FIG.5

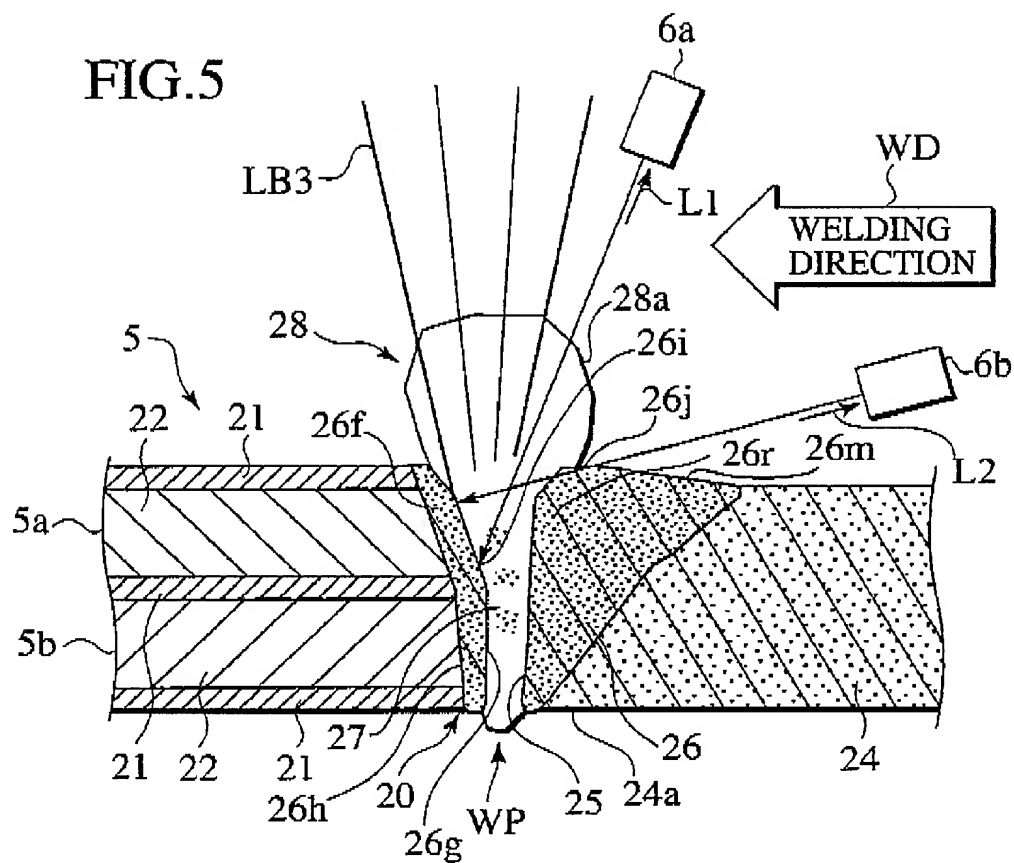
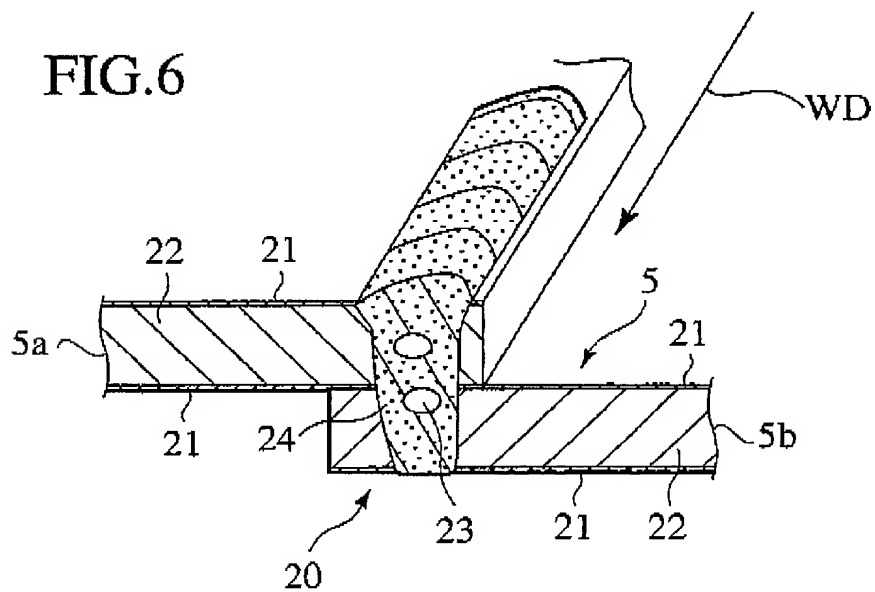
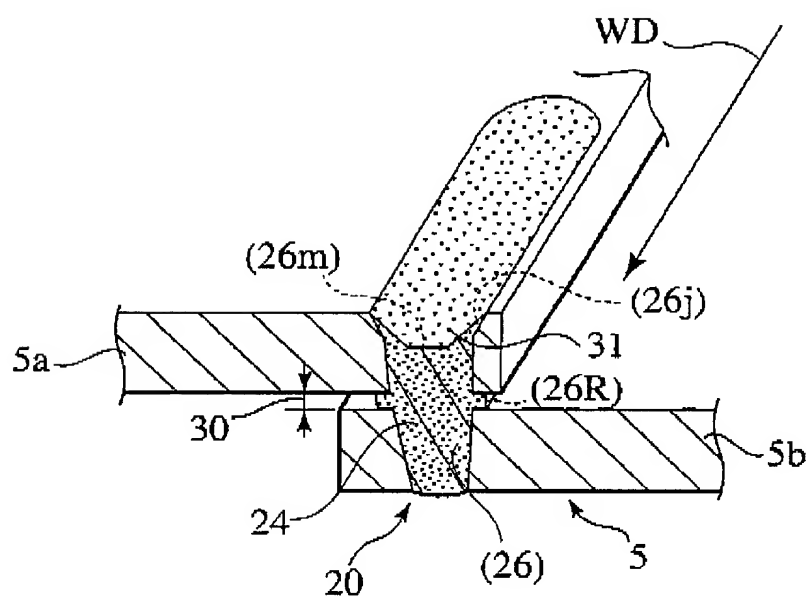


FIG.6



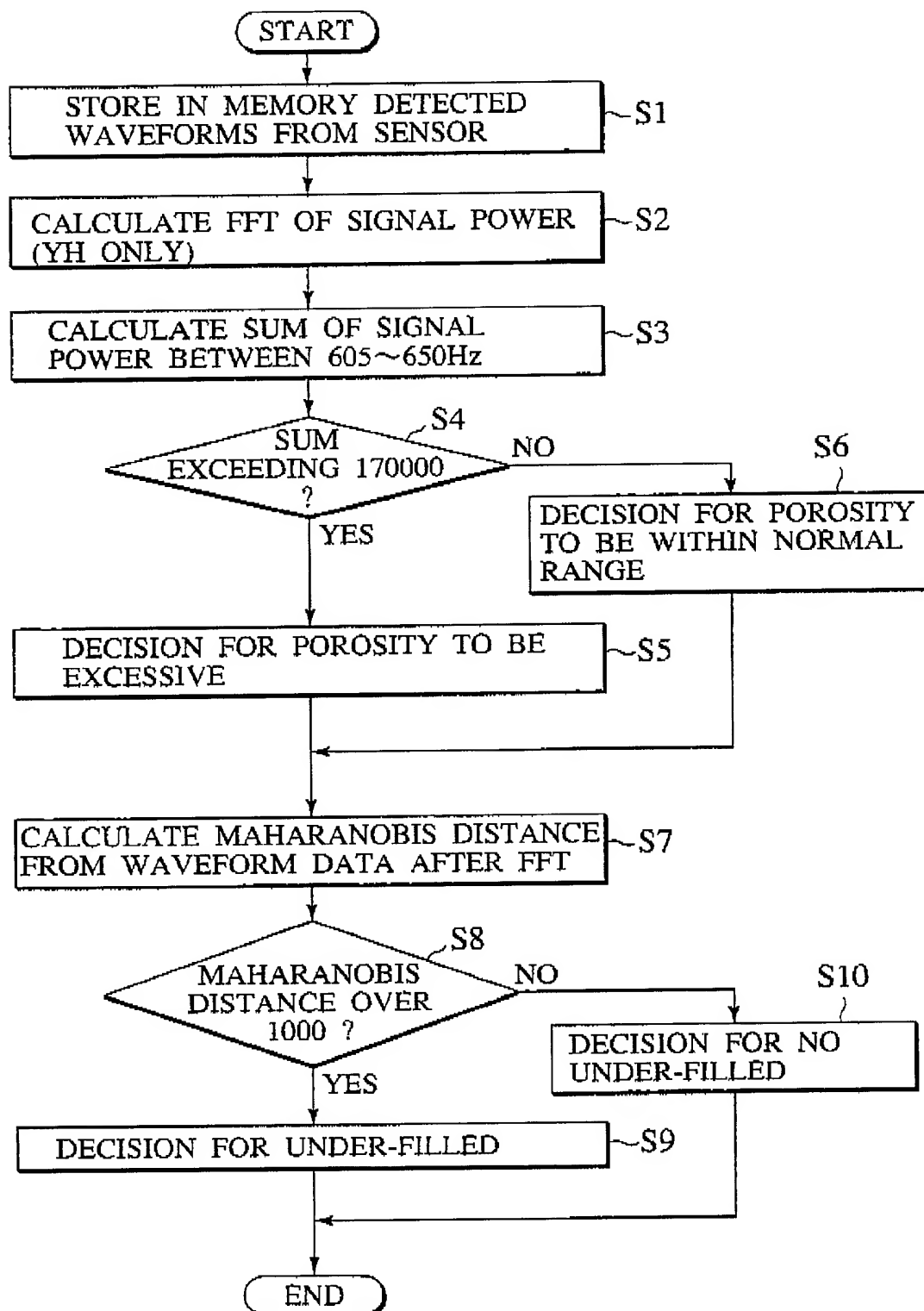
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FIG.7



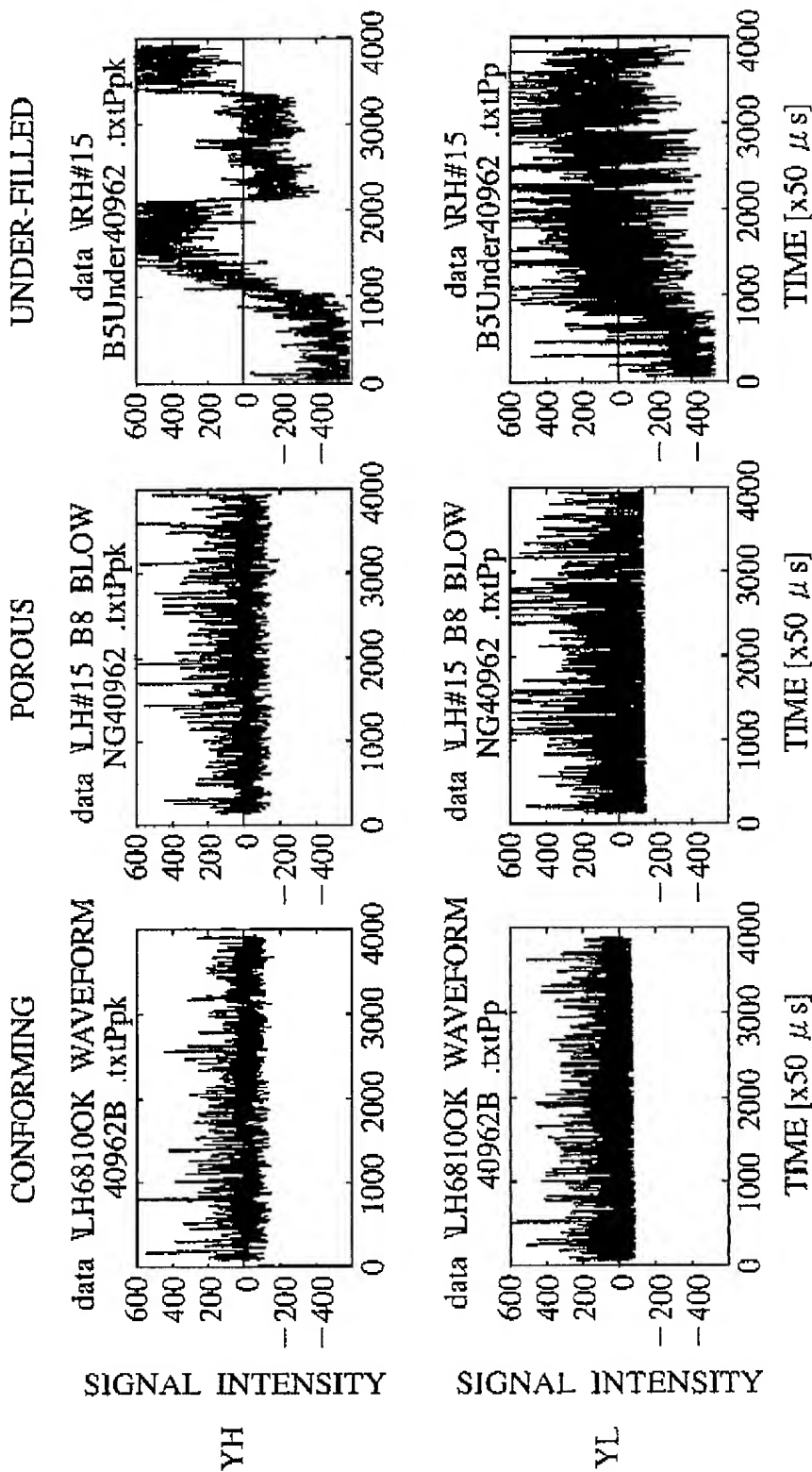
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FIG.8



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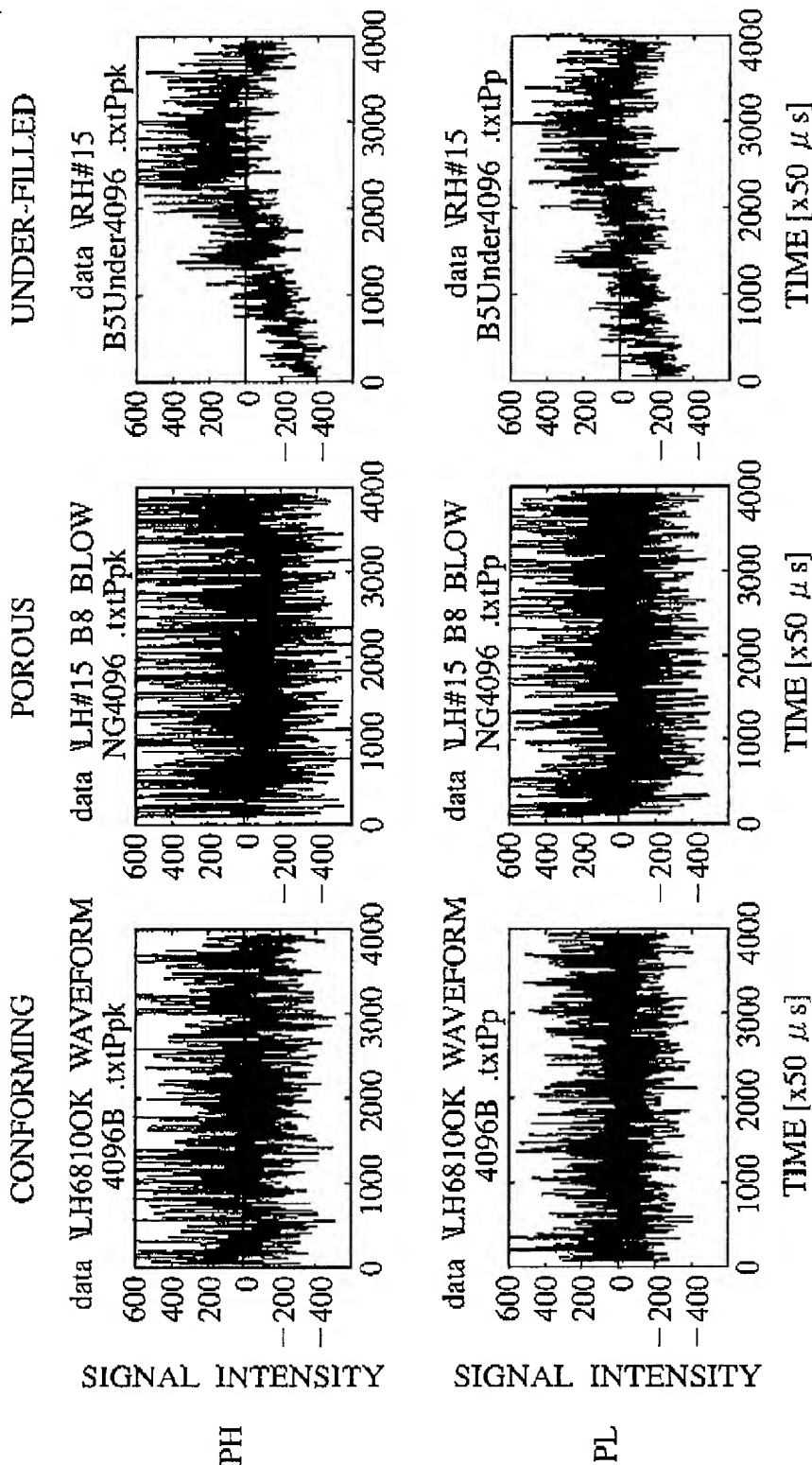
FIG.9



DETECTED WAVEFORMS UNDER BASIC WELDING CONDITIONS

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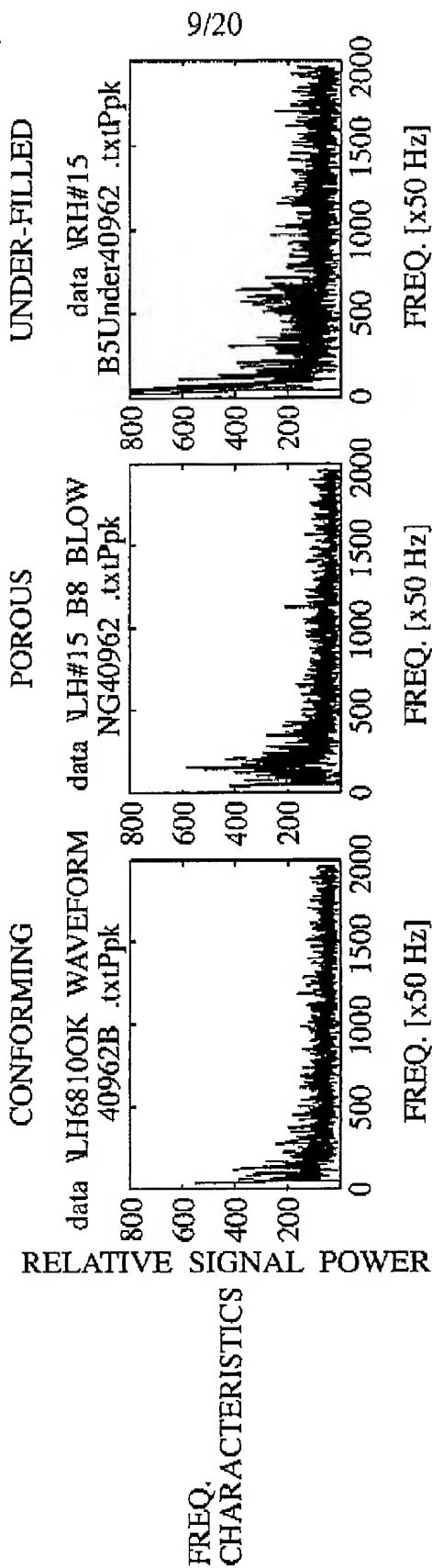
FIG.10



DETECTED WAVEFORMS UNDER BASIC WELDING CONDITIONS



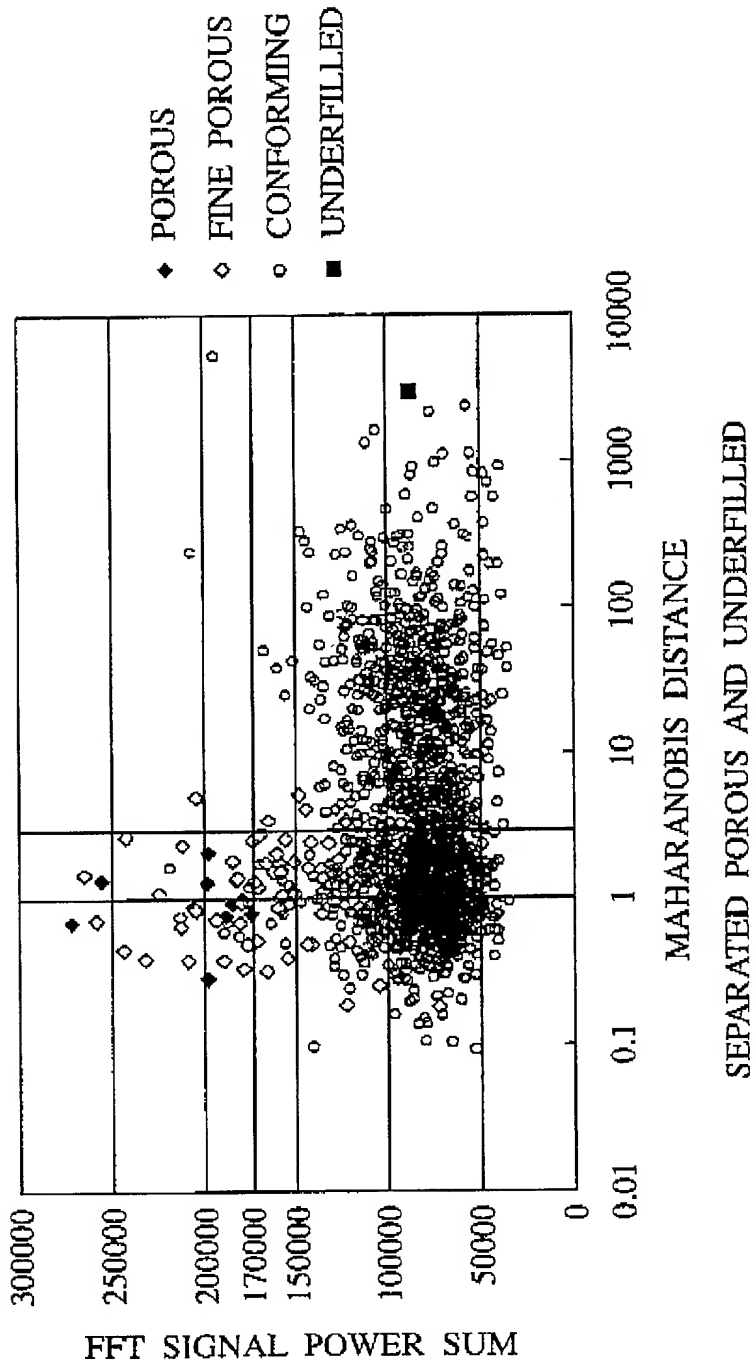
FIG.11



FREQ. CHARACTERISTICS OF YH

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FIG.12



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FIG.13

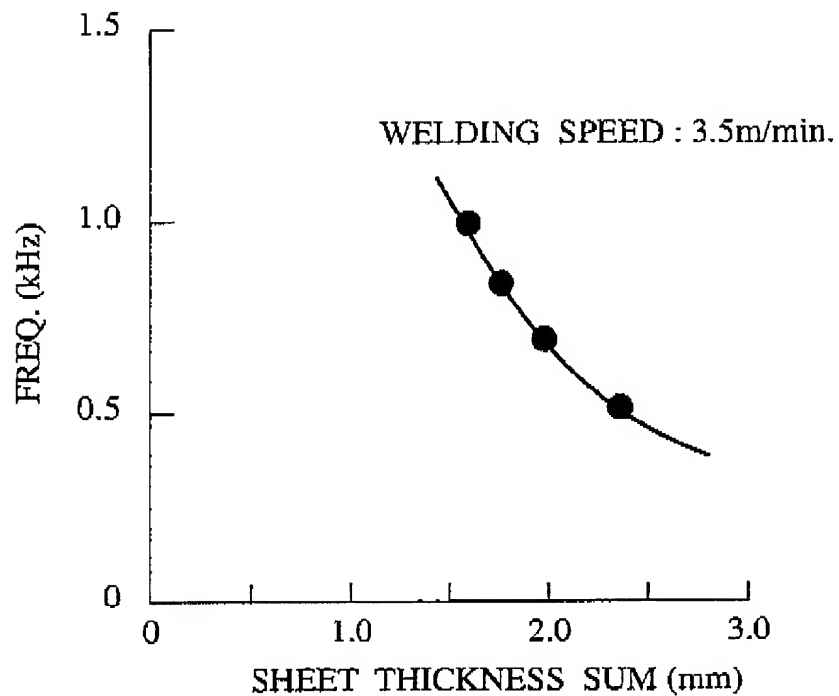
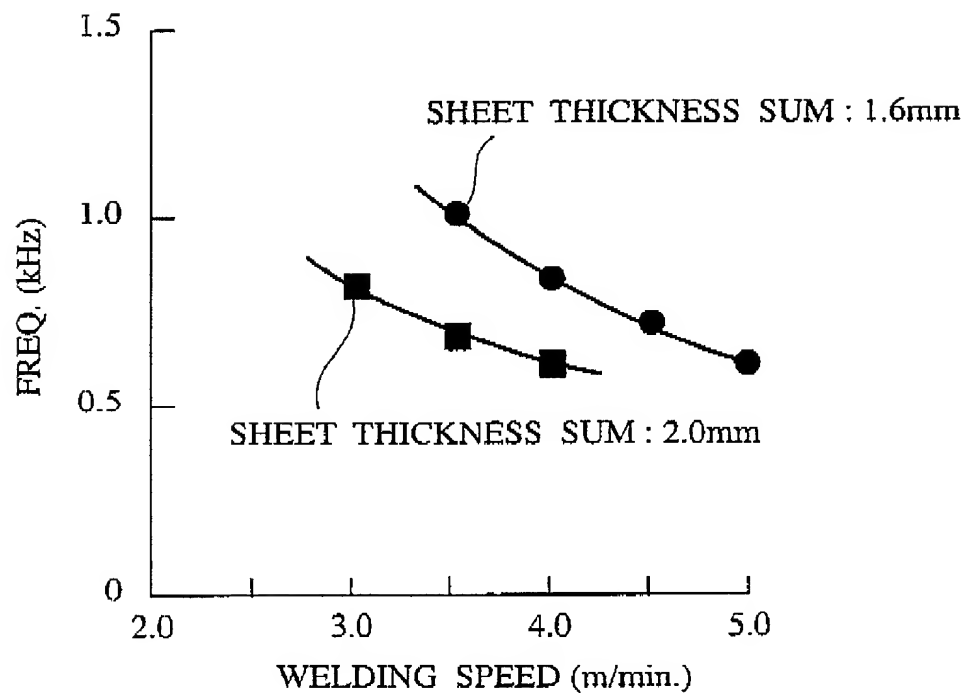


FIG.14



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FIG.15

TABLE-1

	LOWER/UPPER	UPPER SHEET t <sub>1</sub>		
		0.8mm	1.0mm	1.2mm
LOWER SHEET t <sub>2</sub>	0.8mm	3.5m/min.	3.5m/min.	3.5m/min.
	"	4.0m/min.		
	"	4.5m/min.		
	"	5.0m/min.		
	1.0mm	3.5m/min.		
	1.2mm	3.0m/min.		
	"	3.5m/min.		3.5m/min.
	"	4.0m/min.		

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FIG.16

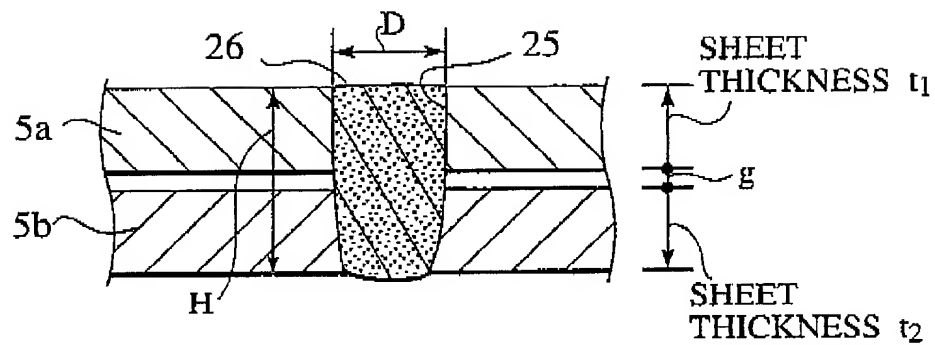


FIG.17

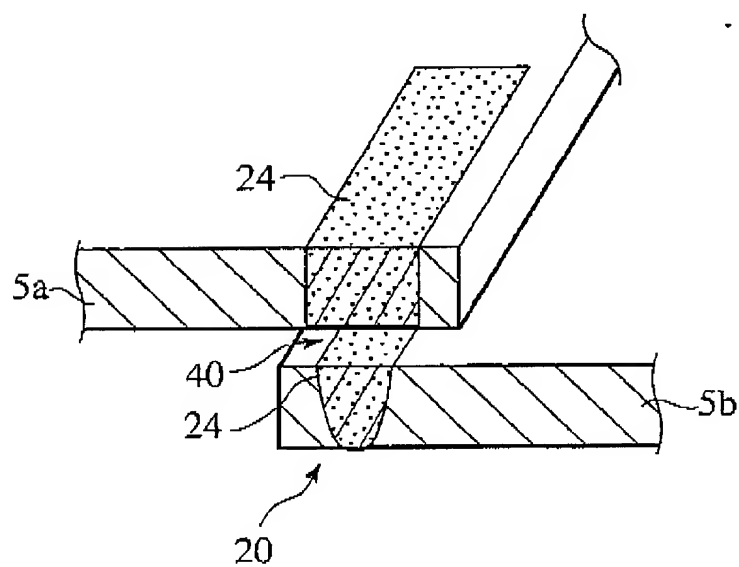
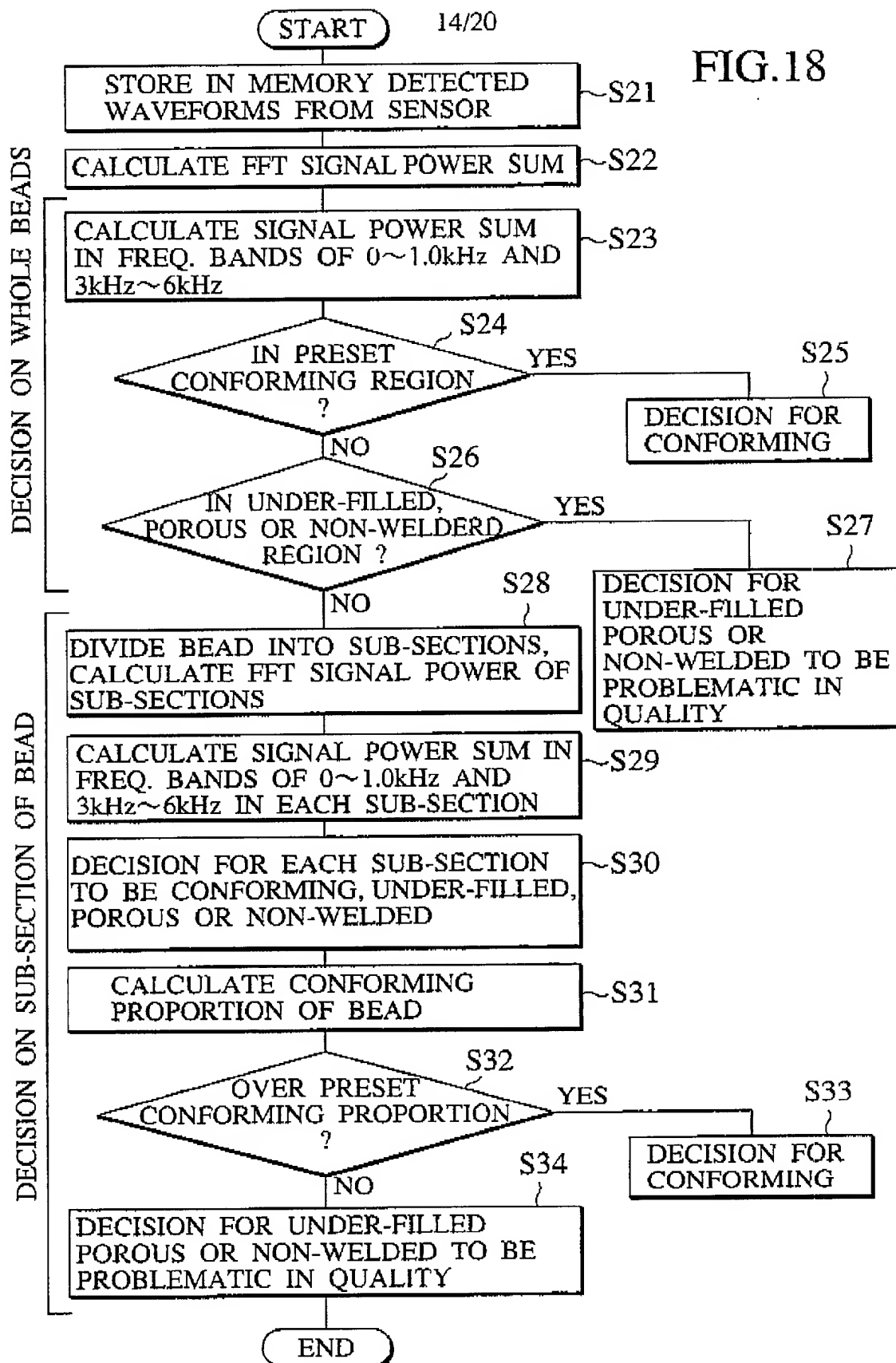
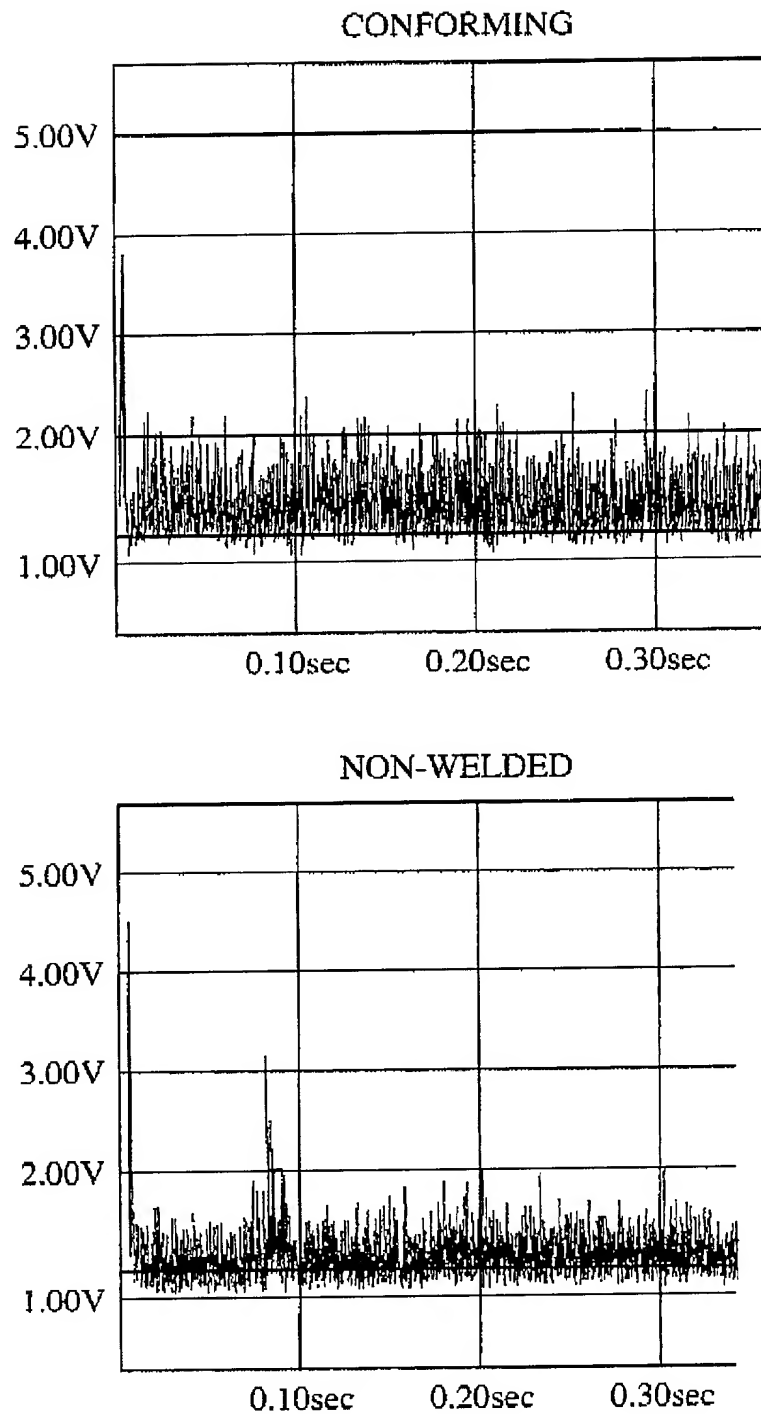


FIG.18



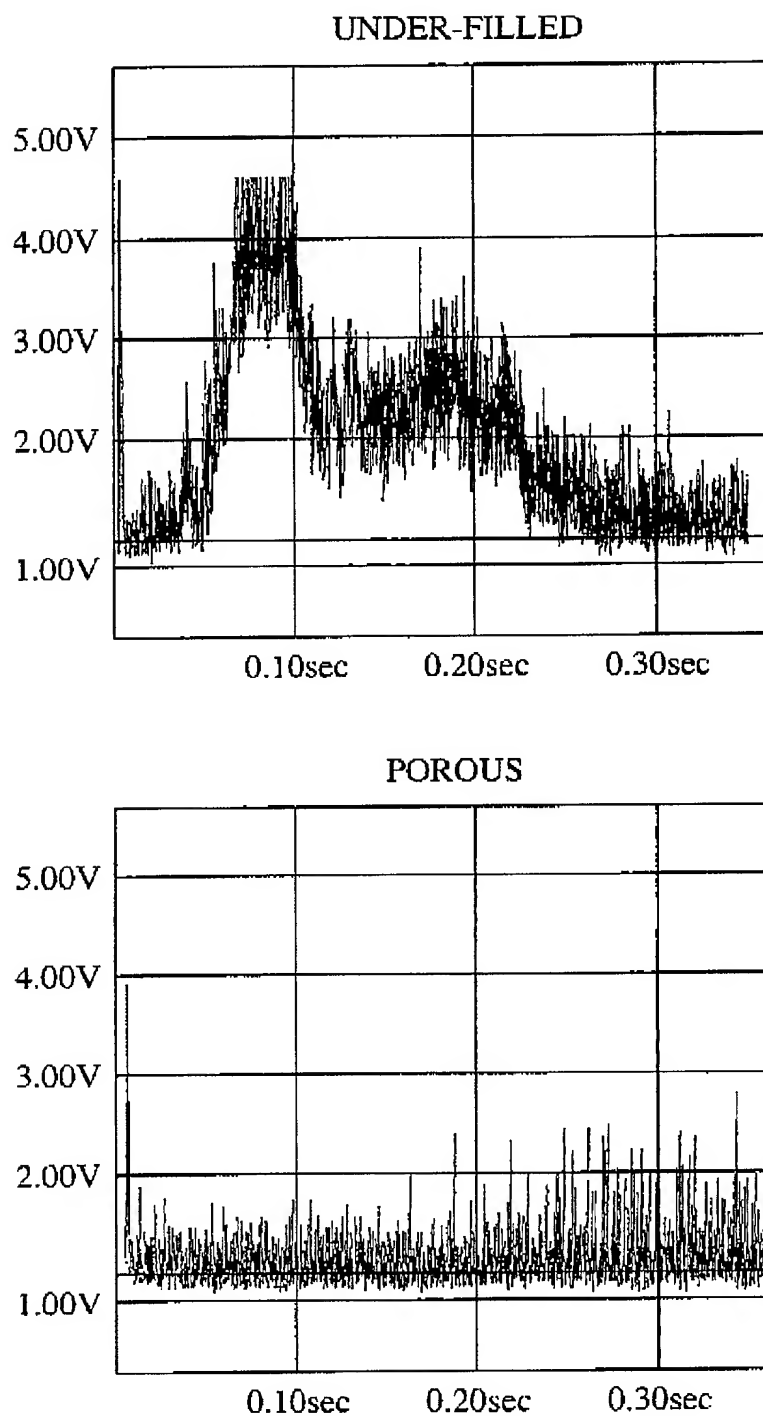
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FIG.19



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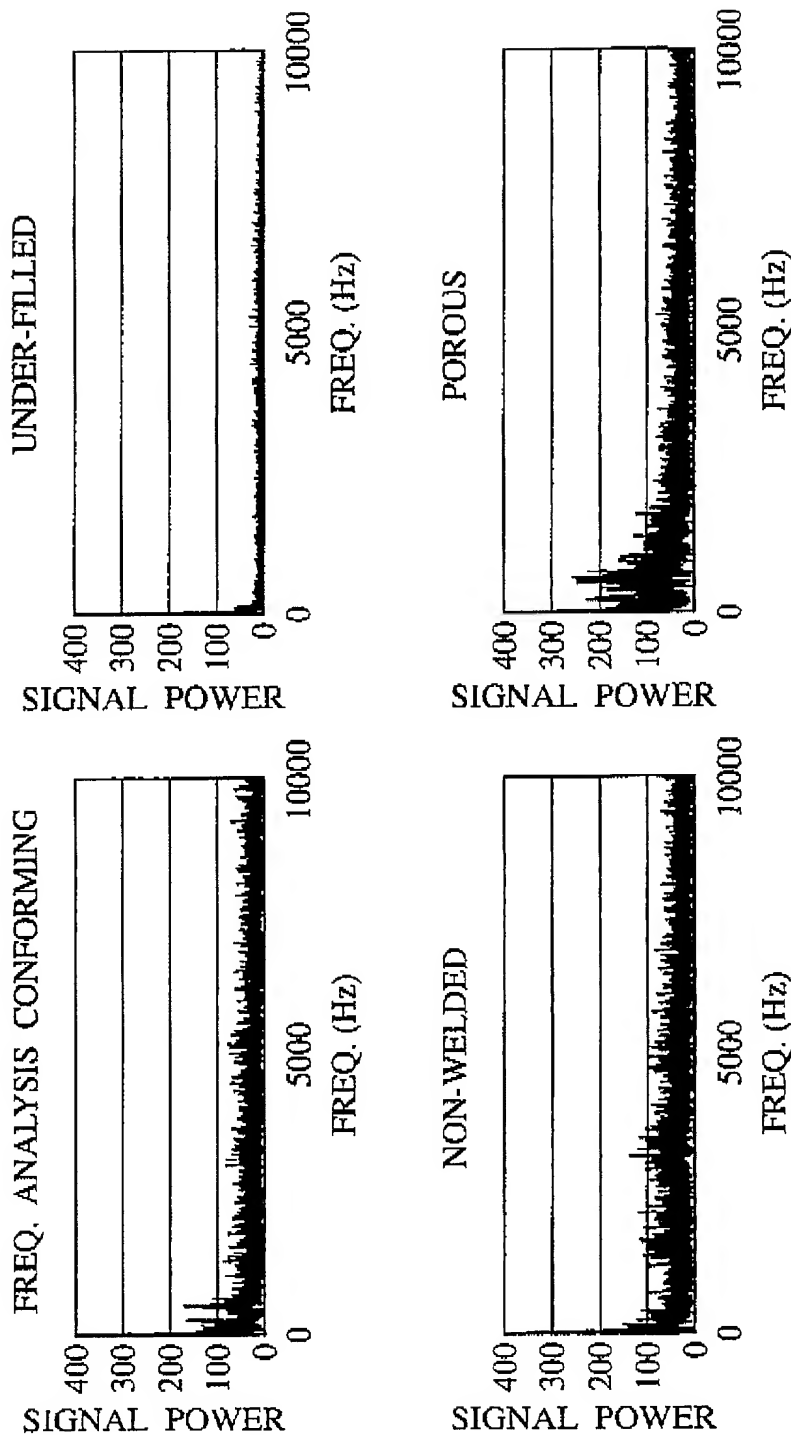
FIG.20





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FIG.21



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FIG.22

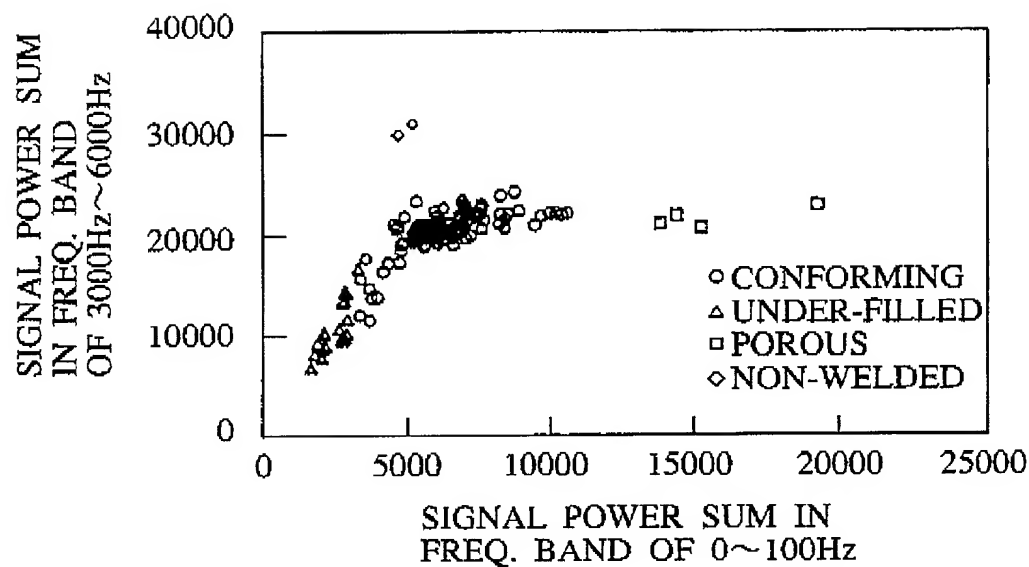
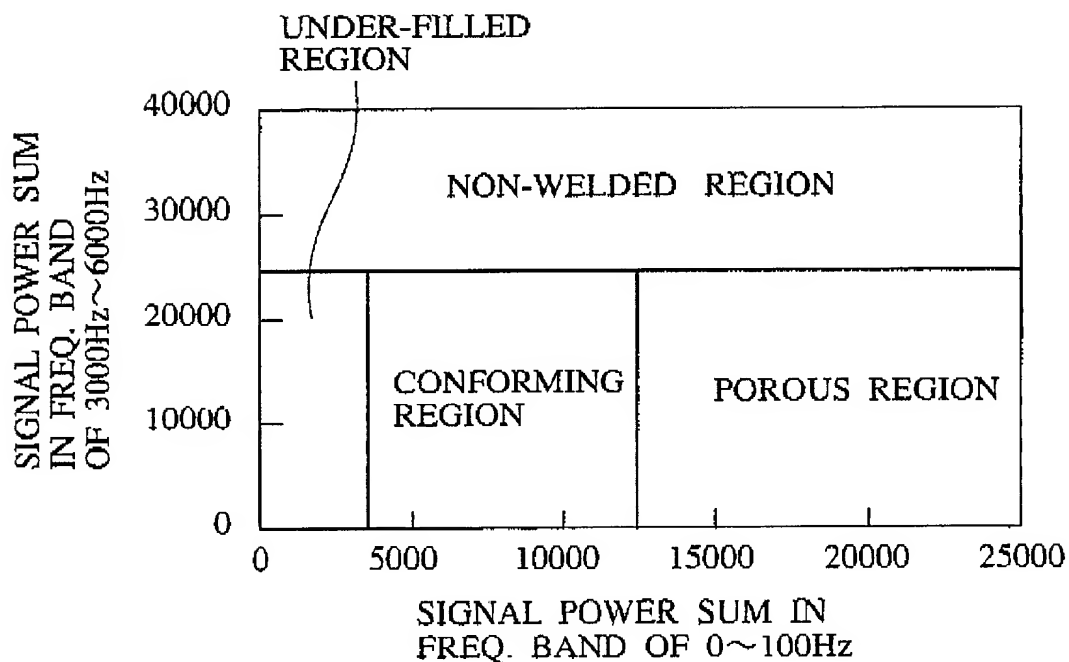


FIG.23



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FIG.24

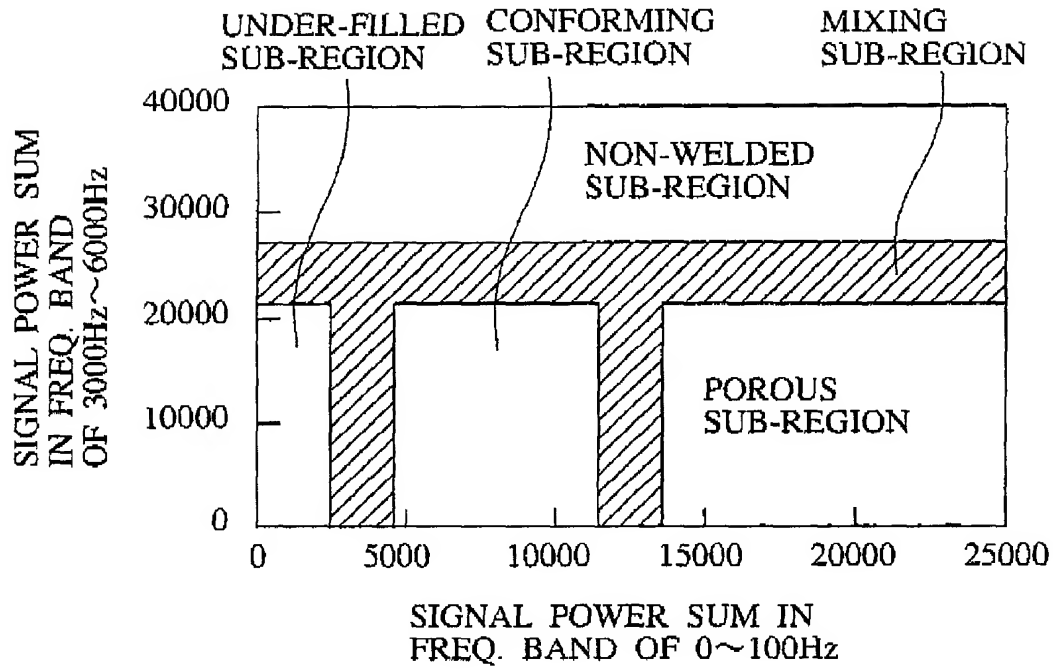
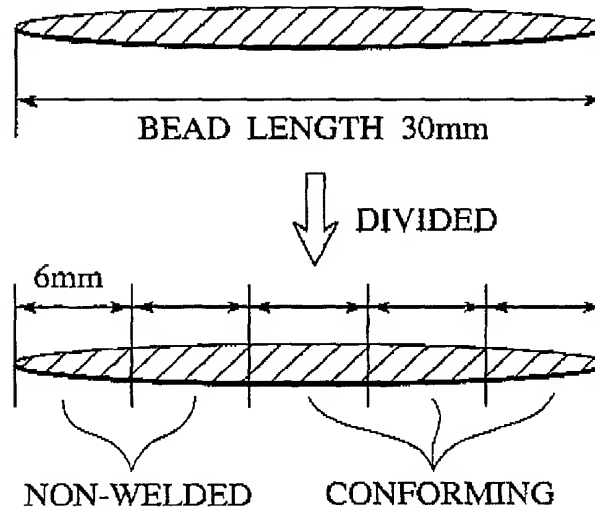


FIG.25



$$\text{CONFORMING PROPORTION} = \frac{\text{CONFORMING LENGTH 6mm} \times 3 \text{ SUB-SECTIONS}}{\text{TOTAL WELD LENGTH 30mm}} = 0.6$$

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FIG.26

